

Date: Wednesday, 5/23/2007 3:24:23 PM  
User: Kim Johnston

## Process Sheet

## SPLIT-

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: PLUG
Job Number	: 32466		
Estimate Number	: 10512		
P.O. Number	: N/A	Part Number	: D26511
This Issue	: 5/23/2007	S.O. No.	: N/A
Prsht Rev.	: NC	Drawing Number	: D2651 REV. B
First Issue	: N/A	Project Number	: N/A
Previous Run	: 32118	Drawing Revision	: B
		Material	: N/A
Written By	: <u>HA 07.05.24</u>	Due Date	: 6/6/2007
Checked & Approved By	: <u>HA 07.05.24</u>	Qty:	200
Comment	: Est: A 02.04.15 New Issue NG	Um:	Each
	: Est: B 05.12.12 added deburr EC		

### Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6R0500	6061-T6 Round Bar 500"
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Comment: Qty.: 0.0421 f(s)/Unit Total : 8.4210 f(s) *M104619 87" [7.25]*  
Material: 6061-T6 (QQ-A-225/8) 0.500" Dia  
(M6061T6R0500)  
Batch: *M103961 28" [2.3]* (K)

RQ 07/06/20

2.0	HARDINGE	HARDINGE CNC LATHE SMALL
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Comment: HAAS CNC VERTICAL MACHINING #1 *Harding = CNC lathe*  
1- Turn as per Folio FA219 and Dwg D2651  
2- Deburr

RC MS 01/06/20

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

x 220

20. MS 07/06/20

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

36 07-06-20 220

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1  
Deburr ias per dwg D2651

mul 07/6/26 x220

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: ED Date: 07/10/04  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



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Drawing Name: PLUG

Job Number: 32466

Part Number: D26511

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



44K

Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

M.L.

07/06/27

7.0

~~POWDER COATING~~

POWDER COATING



Comment: ~~POWDER COATING~~

~~Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3~~  
(Only larger section necessary)

spray paint  
Delfleet Blue + clear

issue P.O 4053  
Atelier Deloselze

06/06/27  
44

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

07.07.03

counted 45

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

First Month

07/17/4

45

10.0

QC21

FINAL INSPECTION/W/O RELEASE



45

Comment: FINAL INSPECTION/W/O RELEASE

07/10/04

Job Completion



07.07.04

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries





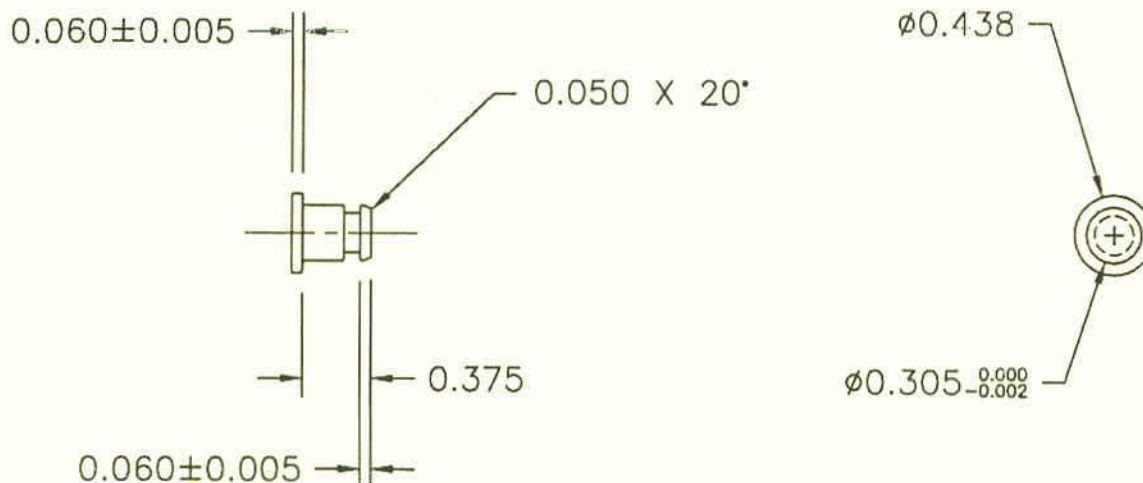
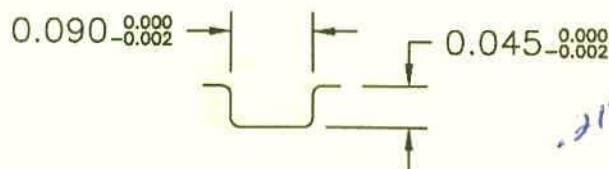
1870  
The following is a list of the names of the persons who have been  
admitted to the membership of the Society since the last meeting.  
The names are given in alphabetical order of their surnames.  
The names of the persons who have been admitted to the membership  
of the Society since the last meeting are given in alphabetical order  
of their surnames.

**DART**

DESIGN #	DRAWN BY #	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D2651	REV. B SHEET 1 OF 1
DATE 03.12.19		TITLE PLUG	SCALE 1:1
A	97.03.25	NEW ISSUE	
B	03.12.19	ADD POWDER COAT, MS28775-008	

**RELEASED**

03.12.19 #

D2651-1 PLUG:GROOVE DETAIL (SCALE 5:1)D2651-1 PLUG

- 1) MATERIAL: 6061-T6 (QQ-A-225/8) OR 1100-0 (QQ-A-225/1)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1  
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.010 MAX

D2651-3 O-RING

- 1) MATERIAL: BUNA N, 70 DUROMETER  
3/16 ID, 5/16 OD, 1/16 WIDTH  
(PARKER 2-008, MS28775-008 OR EQUIVALENT)

SHOP COPY  
RETURN TO  
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UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 32466

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